

Work Order ID 56748-1

March 8, 2010 9:14:52 AM

Page 1

Item ID: D2572

Accept

Revision ID:

Item Name: Saddle, Fwd In 205

Start Date: 09/03/2010 Start Qty: 8.00

Required Date: 09/03/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No.

Double check by:

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2571 & D2572

1

Ø

1

Ø

12.03/10

DJR 10/03/11

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Setup Start



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Stop



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Customer:

Reference:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
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Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

M/V 10/03/10

1

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

L.S 10/03/10

1

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

BR 10 3-12

0. 0.

Hand Finishing

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:35

OVEN TEMPERATURE: 326°

FINISH TIME: 8:05

BK 10-3-12 D.

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/6/12



170

Identify as per dwg & Stock Location: 433

0.00



Packaging

Memo

0.00

Packaging

10-3-12 28



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Stop



Start Date: 09/03/2010 Start Qty: 8.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/16 *[Signature]*

ME

10-3-12

Picklist Print

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Page 1

Work Order ID: 56748



Parent Item: D2572



Parent Item Name: Saddle, Fwd In 205

Start Date: 09/03/2010

Required Date: 09/03/2010

Comments: IPP: I002.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	106.0000	8.0000			



Saddle Billet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

46411

106

106

MMZ
10/03/09

8

DART AEROSPACE LTD		Work Order: 56748
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		440					
B	1.745	1.755		1.751					
C	3.495	3.505		3.498					
D	1.745	1.755		1.747					
E	7.990	8.010		8.003					
F	0.490	0.510		501					
G	0.257	0.262		250	0.259	0.259	0.259		
H	0.375	0.380		377	0.377	0.377	0.377		
I	0.490	0.510		501					
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		569					
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		126	0.126	0.125			
Q	0.115	0.135		130					
R	0.240	0.260		250	0.248	0.249			
S	0.115	0.135		130	0.130				
T	0.178	0.198		188	0.188	0.188			
U	2.940	2.980		2.957	2.958	2.958			
V	0.230	0.250		241	0.241				
W	0.115	0.135		121					
X	0.307	0.312		0.315					
Y	0.760	0.765		0.761					
Z	0.352	0.372		360					
AA	0.470	0.530		500	0.500	0.500	0.500		
AB	0.615	0.635		617					
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		250	0.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		135					
AG	0.240	0.280		250	0.255	0.255	0.255		
AH	0.240	0.260		248	0.248				
AI	2.000	2.020		2.002	2.000				
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by: <u>DJP</u>	Audited by: <u>[Signature]</u>
Date: <u>10/03/11</u>	Date: <u>10/03/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	